

Date: Thursday, 2/9/2006 1:17:21 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE ASSEMBLY		
Job Number	: 25793					
Estimate Number	: 11527					
P.O. Number	: N/A			Part Number	: D3021041	
This Issue	: 2/9/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D3021 REV A	
First Issue	: N/A		Type	: LARGE FAB ASSY		
Previous Run	: N/A			Project Number	: N/A	
Written By	: <u>See COMMENT Below</u>			Drawing Revision	: A	
Checked & Approved By	: <u>OK 06.02.09</u>			Material	: N/A	
Comment	: Est. 01.10.20 New Issue SM			Due Date	: 2/25/2006	
					Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M4130NT0750W049	4130 Tube .750 OD x.049W	
		Comment: Qty.: 2.1875 f(s)/Unit Total : 2.1875 f(s) 4130 Tube .750 OD x.049W Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall batch: <u>M10133</u>	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 1-Cut tube as per Dwg D3021 2-Drill tube as per Dwg D3021 using D3021-041T1 3--Deburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	M4130NS049	4130 Sheet .049 wall	
		Comment: Qty.: 1.0500 sf(s)/Unit Total : 1.0500 sf(s) 4130 Sheet .049 wall Cut:- AISI 4130N sheet, 18 gauge (0.050 thick) batch: <u>M16443</u> Identify For D3017-11 Cap	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut end caps as per Dwg D3017

AD 06/02/13

2-Weld as per Dwg D3021

A/R Steel Rod Batch: MG430

6.0 QC5/9

WELD INSPECTION



Comment: VISUAL WELDING INSPECTION

Inspect Level 9

Inspect for forein objects per QSI 024

PD 06-02-13

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 02 21

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/02/21

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/02/21

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sur 06/02/22

(1)

(2)

06/02/22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

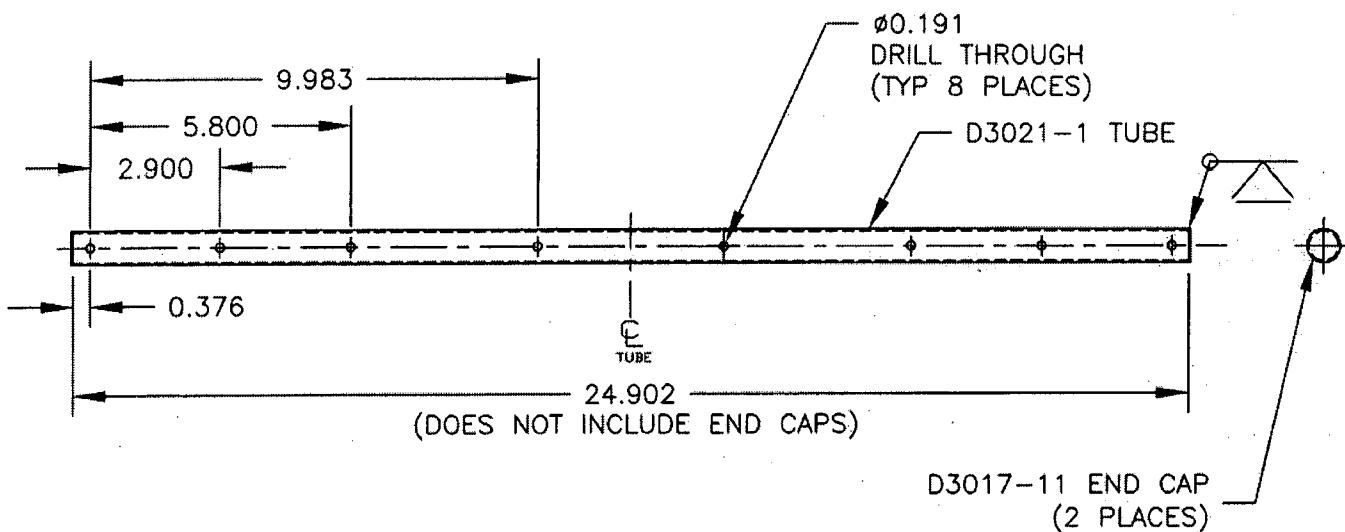
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3021	SHEET 1 OF 1
DATE		TITLE	SCALE
01.05.18		TUBE ASSEMBLY	1:4
A	01.05.18	NEW ISSUE	

**NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W0490)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30 *SP*

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WORK ORDER
25793

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